

Work Order ID 53201

October 26, 2009 12:41:14 PM



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Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	26/10/2009	Start Qty: 1.00		Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty: 1.00		Customer:		
Reference:						

Approvals:	Process Plan:		Date:	09-10-26	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: <u>M109213</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

Signature 09/10/29

Signature 09 10 29

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Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	26/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	04/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat	Memo	0.00							
Powder Coating	1- Plug holes prior to								

1ST COAT:
 START TIME: 11:45am
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 12:45pm
 ***** 2nd coat if necessary *****
 2ND COAT:
 START TIME: 1:00pm
 OVEN TEMPERATURE: 400°F
 FINISH TIME: 1:30pm

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Item ID: D2221
Revision ID: H
Item Name: 350 Basket Base

Accept



Setup Start



Stop



Start Date: 26/10/2009 Start Qty: 1.00
Required Date: 04/11/2009 Req'd Qty: 1.00



Cust Item ID:
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	QC3- Inspect Part Finish	0.00	BR 09-11-4			①.			
QC Quality Control	Memo	0.00							
150 	QC21- Final Inspection - Work Order Release	0.00	09/11/05			PAP 53198			09/11/05
QC Quality Control	Memo	0.00							

IDENTIFY & STOCK

BR 09-11-5

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Work Order ID: 53201

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2221-1RevH

Manufactured

No

100

Each

13.0000

1.0000



Rib

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

12

51872

12

1x

SY 09/10/26

D2221-5RevH

Manufactured

No

100

Each

2.0000

2.0000



Rib

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

50026

2

2x

SY 09/10/26

D2221-7RevH

Manufactured

No

100

Each

5.0000

1.0000



Rib

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

5

51090

1

51251

4

1x

SY 09/10/26

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Work Order ID: 53201

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	13.0000	2.0000			



Basket Hinge



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

50024

2

51870

11

D2235-1RevB1

Manufactured

No



Basket Rib



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

51438

7

Main Warehouse

WA

13

50565

3

51871

10

2x 09/10/26

2x 09/10/26

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Shop Packet Print

Page 2

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Work Order ID: 53201

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1		Manufactured	No			100	Each	66.0000	2.0000			



Mounting Bracket

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	13	
46086	2	
48428	1	
51120	10	
Main Warehouse		
WA	53	
50872	4	
51745	49	

1x *SL 09/10/26*

1x

D3442-1RevA

Manufactured No

100

Each

18.0000

2.0000



Shim

✓

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1	
46767	1	
Main Warehouse		
WA	17	
50951	17	

2x *SL 09/10/26*

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Work Order ID: 53201



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	8.0000	2.0000			

Rib Assembly (Basket End)



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51869	6	
Main Warehouse		
WA	2	
51171	2	

2x *[Signature]* 09/10/26

D3826-041RevB

Manufactured No



Rib / Gusset Assembly



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
51340	6	
Main Warehouse		
WA	2	
51088	2	

2x *[Signature]* 09/10/26

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Work Order ID: 53201



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3827-041RevA		Manufactured	No			100	Each	5.0000	1.0000			

Rib Assembly (Inboard)

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

51339

5

D3832-1RevA

Manufactured

No

100

Each

6.0000

1.0000



Mesh (Base)

✓

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

4

50942

1

51863

3

1x *SY* 09/10/26

1x *SY* 09/10/26

Picklist Print

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Work Order ID: 53201



Parent Item: D2221RevH



Parent Item Name: 350 Basket Base

Start Date: 26/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

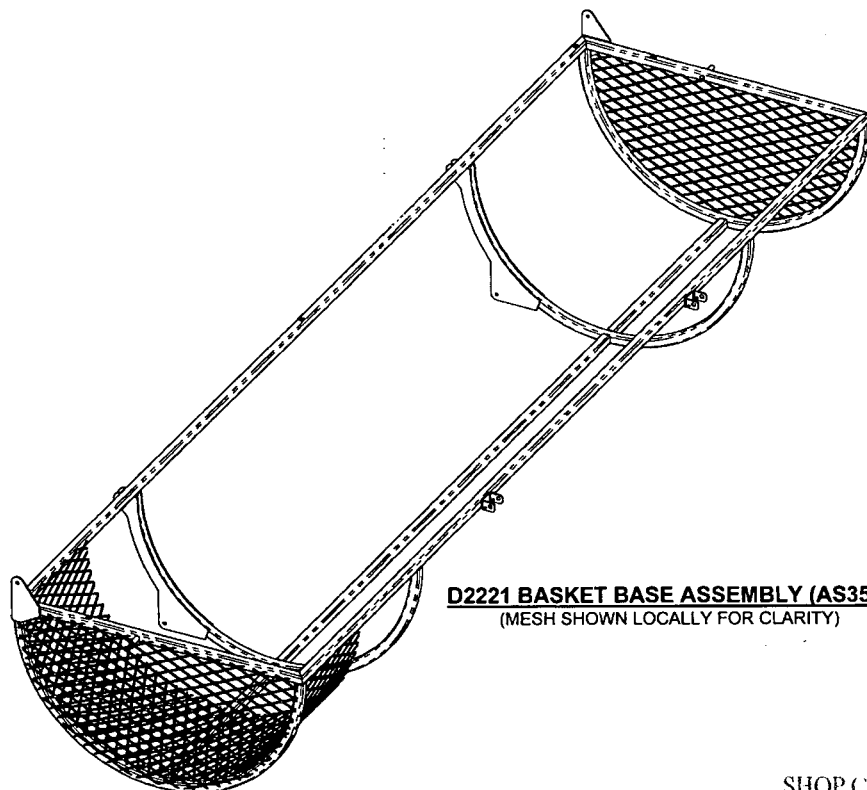
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3833-1RevA		Manufactured	No			100	Each	10.0000	2.0000			

Mesh (Base End Face)



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	8	
51304	8	
Main Warehouse		
WA	2	
50025	2	

2x *SY* 09/10/26



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

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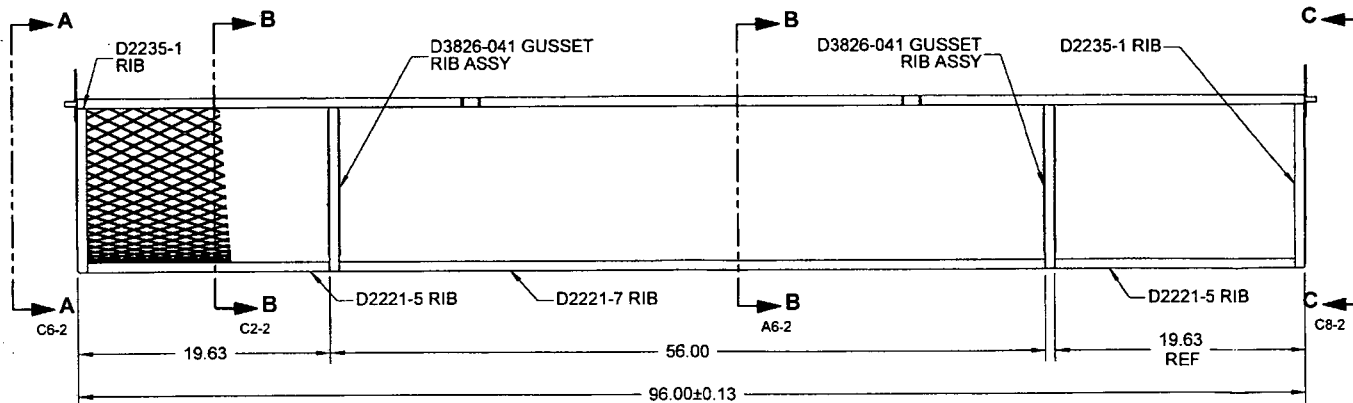
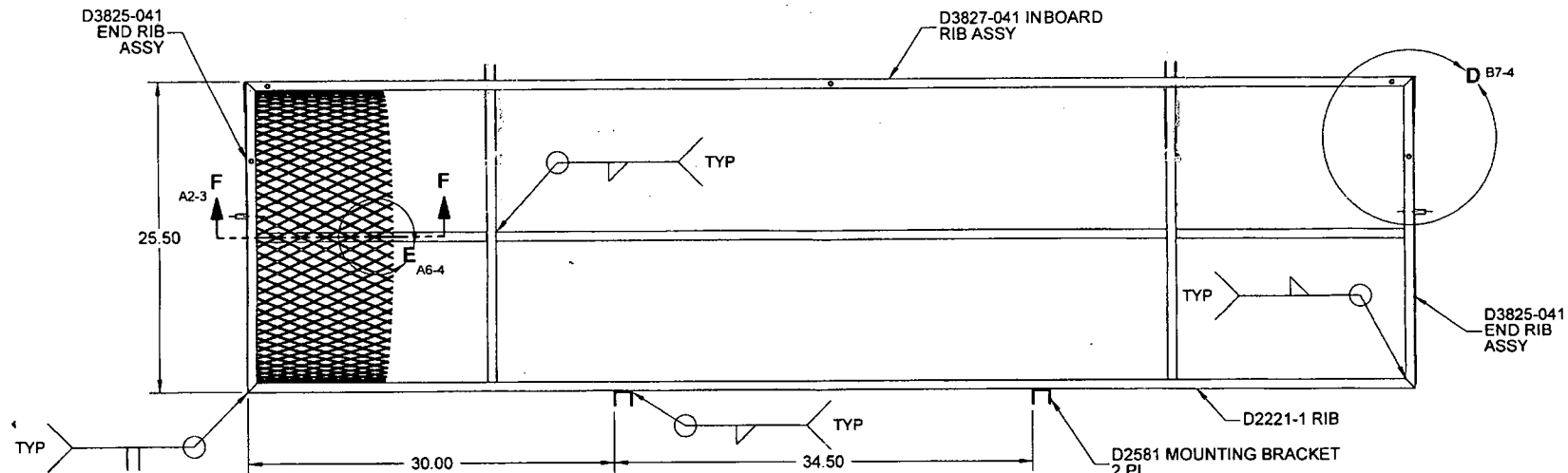
NOTES:
MATERIAL: N/A
FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 42.00 lbs APPROX
MASK ALL HOLES PRIOR TO POWDER COATING

H

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/16

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BW		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

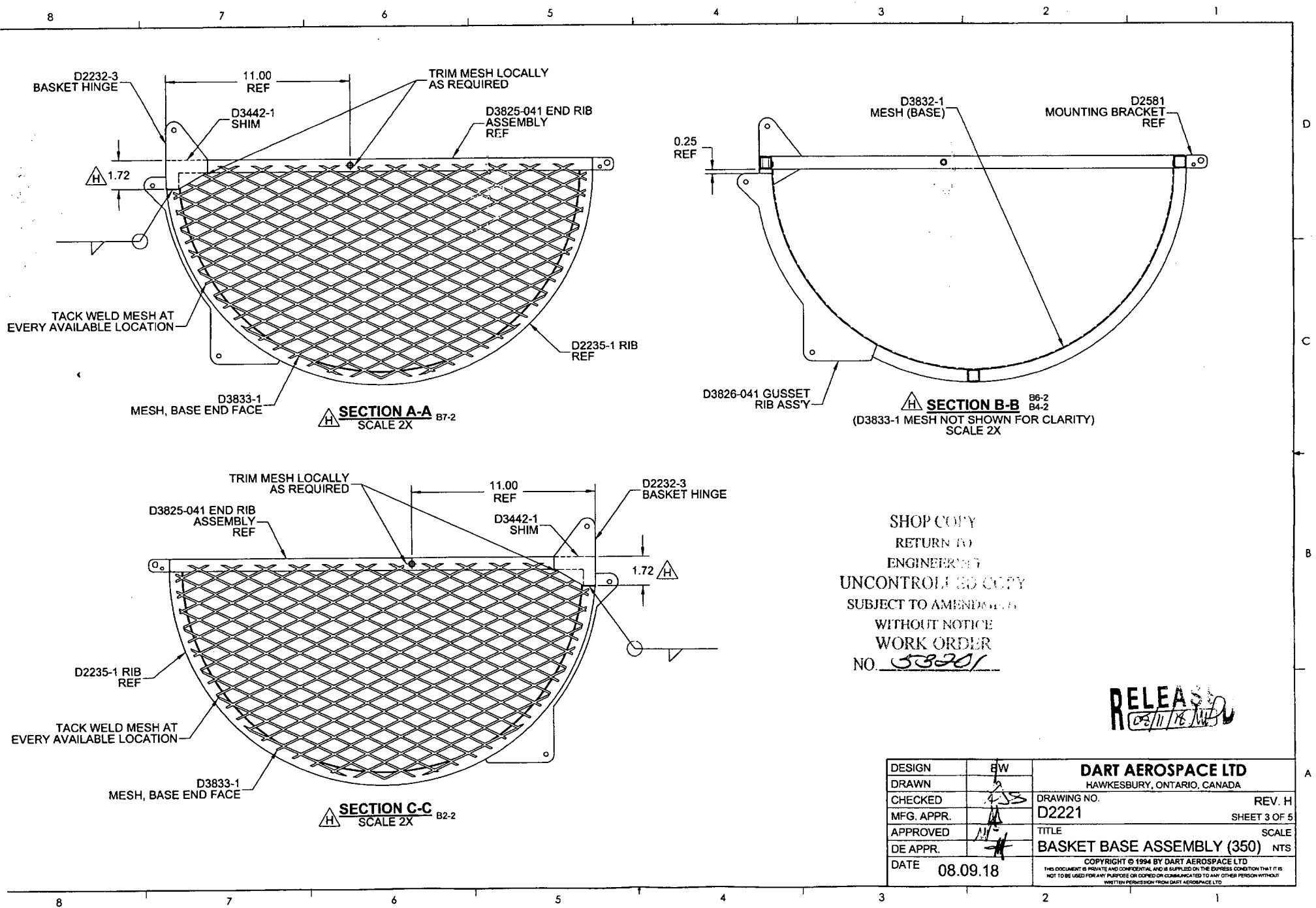


D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

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06/11/18 MLD

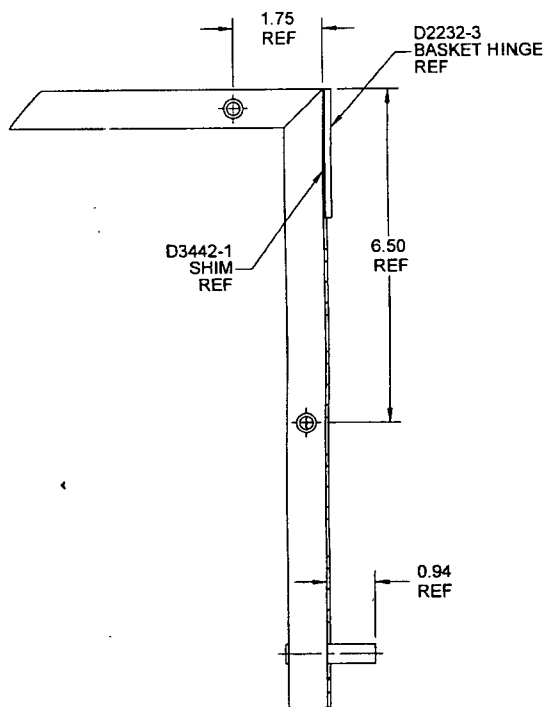
DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
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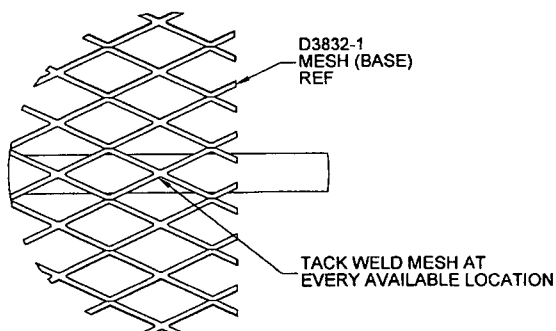
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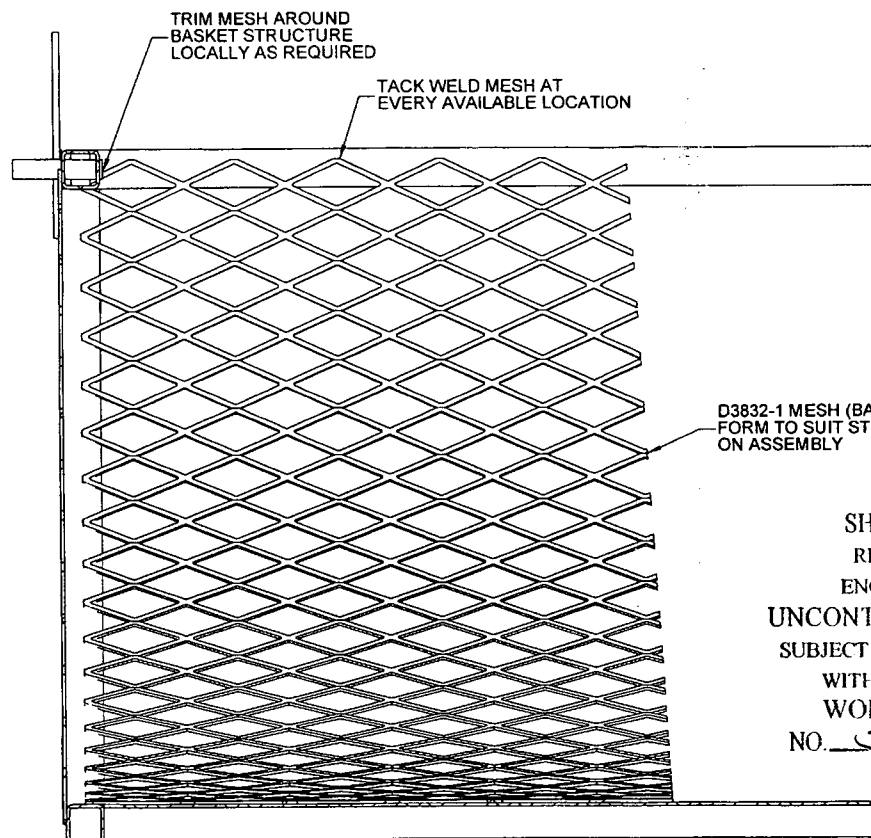
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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	AS	D2221	SHEET 3 OF 5
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET BASE ASSEMBLY (350)	
DATE	08.09.18	NTS	
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DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2

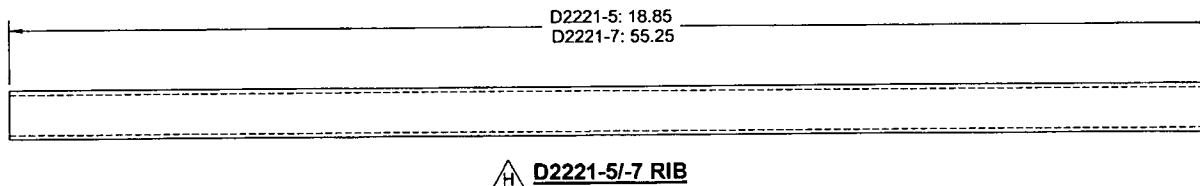
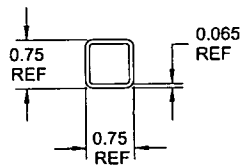
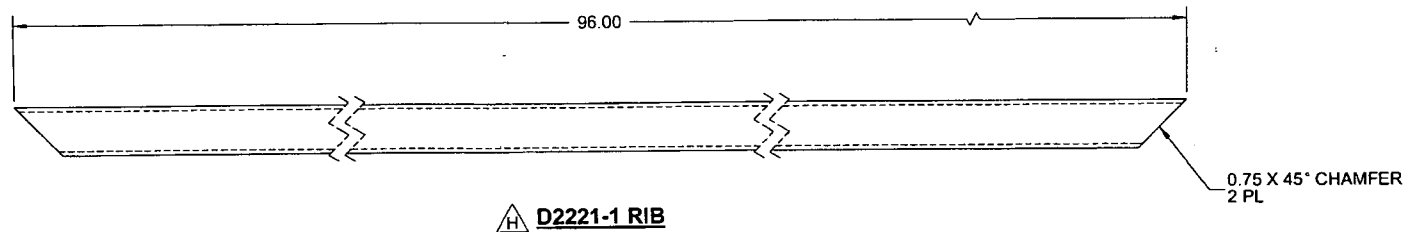
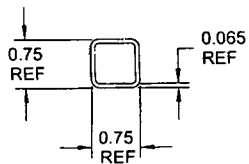


SECTION F-F
SCALE 4X D7-2

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08/11/18 MJD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LS</i>	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 4 OF 5
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



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08/11/18

NOTES:
MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	MT	TITLE	SCALE
DE APPR.	SH	BASKET BASE ASSEMBLY (350) NTS	
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